

Date: Tuesday, 4/18/2006 10:03:16 AM
 User: Kim Johnston

Process Sheet

20

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 26673
 Estimate Number : 10559
 P.O. Number : N/A
 This Issue : 4/18/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : LANDING GEAR
 Previous Run : 26672
 Drawing Name : HIGH AFT X-TUBE 412
 Part Number : D412664203
 Drawing Number : D412-664-243 REV B
 Project Number : N/A
 Drawing Revision : B
 Material : N/A
 Due Date : 5/20/2006 Qty: 1 Um: Each
 Written By : *See Comment Below*
 Checked & Approved By : *06.04.18*
 Comment : Est Rev:E 04.02.16 Reformat; Added D3189-1 K/DS
 Est Rev:F 06-03-29 Remove Coments on Pick List JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D412-664-203 CHG 003

KS 06.05.10 ①

2.0 D6009129 Crosstube Material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6009-129 Crosstube B25942

Check OD = 3.500"; ID = 2.250"

M8 06.05.10 1

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA166

2-Turn first side as per Folio FA166

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.

B6 06.05.12 1

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

B6 06.05.12 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:03:16 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 26673

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA166

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.

3-Polish entire outside surface of crosstube

4- Remove sand and plugs

5-Scribe part # and batch # using vibrating stylus as per Dwg D412-664-243

BG 06-05-12

1

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

BG 06-05-12

1

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

M8 06-05-18

1

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

OK 06-05-18

9.0

QC3/5

INSPECT WORK/WING WALK



Comment: Inspect work & Chemical conversion Coat

DP 06-5-18

10.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

DP 06-5-24

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06-05-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial- Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:03:16 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 26673

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551

IT 06-05-31

2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

06-05-31

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243

PM 06-05-30

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF
A.M

06-05-31

06-05-31

14.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 1384 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

C206/06/020

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

AL 06/06/09

16.0

QC8

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

06-06-12

17.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

FL 06 06 12 ①

2-Paint outside crosstube with White Imron as per QSI 005 4.2

MM 06 06 13 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06-05-31	131	Add QCS.						
		permanent change						
06-06-12	16	Add QCS, remove QCS						
		permanent change						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/06/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:03:17 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 26673

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC14

Inspect Spray Paint



06-06-15 (1)

Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

19.0

D2856600

Abrasion Strip



Comment: Qty.: 1.7640 f(s)/Unit Total : 1.7640 f(s)

Pick:

Qty Part number Description Batch

2 D2856-600(Cut to 10.090") Abrasion Strip

B25656

RT 06-06-22

20.0

D2856600

Abrasion Strip



Comment: Qty.: 1.0080 f(s)/Unit Total : 1.0080 f(s)

Pick:

Qty Part number Description Batch

1 D2856-600(Cut to 10.870") Abrasion Strip

B25656

RT 06-06-22

21.0

D28961

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2896-1 Support

B26683

RT 06-06-22

22.0

D31891

Chafing Shield



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D3189-1 Chafing Shield

B26687

RT 06-06-22

23.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28 Clamp

M106479

RT 06-06-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Date: Tuesday, 4/18/2006 10:03:17 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 26673

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

MS2192030

clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 MS21920-30 Clamp M10054 IT 06-06-22

25.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Assemble as per Dwg D412-664-203 IT 06-06-22

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DD 6-6-28

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

28.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M100327 ✓

29.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M9633 ✓

30.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Washer

Batch: M100191 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:03:17 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 26673

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: M19099 ✓

06/6/28 (1)

32.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AR 06/06/28 (1)

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-203

Location: 5

PPP Rev: 0

06/6/29

34.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/20 (1)

Job Completion



W 06-06-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 26673
Description: Crosstube Assembly (412 High Aft)	Part Number: D412-664-243
Inspection Dwg: D412-664-243 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.684	+0.005/-0.000	2.687	✓		
	2.748	+0.005/-0.000	2.750	✓		
	2.884	+0.005/-0.000	2.887	✓		
	3.019	+0.005/-0.000	3.024	✓		
	3.163	+0.005/-0.000	3.168	✓		
	3.308	+0.005/-0.000	3.310	✓		
	3.429	+0.005/-0.000	3.432	✓		
	2.990	+0.005/-0.000	2.992	✓		
	2.618	+0.005/-0.000	2.622	✓		
	0.200	+/-0.010	.200	✓		
	R0.063	+/-0.010	.063	✓		
	R0.500	+/-0.010	.500	✓		
	4.971	+/-0.001	4.970	✓		
SIDE B	2.684	+0.005/-0.000	2.688	✓		
	2.748	+0.005/-0.000	2.753	✓		
	2.884	+0.005/-0.000	2.888	✓		
	3.019	+0.005/-0.000	3.024	✓		
	3.163	+0.005/-0.000	3.166	✓		
	3.308	+0.005/-0.000	3.310	✓		
	3.429	+0.005/-0.000	3.431	✓		
	2.990	+0.005/-0.000	2.994	✓		
	2.618	+0.005/-0.000	2.623	✓		
	0.200	+/-0.010	.200	✓		
	R0.063	+/-0.010	.063	✓		
	R0.500	+/-0.010	.500	✓		
	4.971	+/-0.001	4.971	✓		
	124.09	+/-0.020	124.09	✓		

Measured by: BC	Audited by: MB	Prototype Approval:	N/A
Date: 06.05.12	Date: 06/05/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.16	New Issue (P/O D412-664-203)	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D412-664-243	REV. B SHEET 1 OF 3
DATE 05.02.04		TITLE CROSSTUBE ASSEMBLY (412 HI AFT) NTS	
A	01.10.17	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.06.09 [Signature]

Qty	Part Number	Description
X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
1	D6009-129	CROSSTUBE
1	D2896-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
1	D2856-600-1087	ABRASION STRIP
4	MS21920-28	CLAMP
2	MS21920-30	CLAMP
2	D3189-1	CHAFING SHIELD

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129
FINISHED LENGTH = 124.09±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 AND D2856-600-1087 ABRASION STRIPS WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2896-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTINAL TO TO SEAL EDGES OF SUPPORTS USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

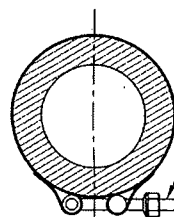
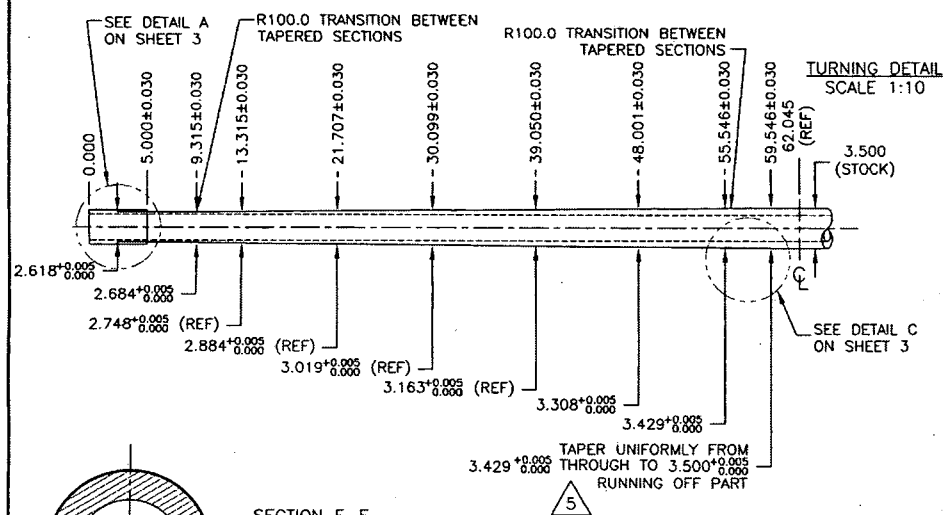
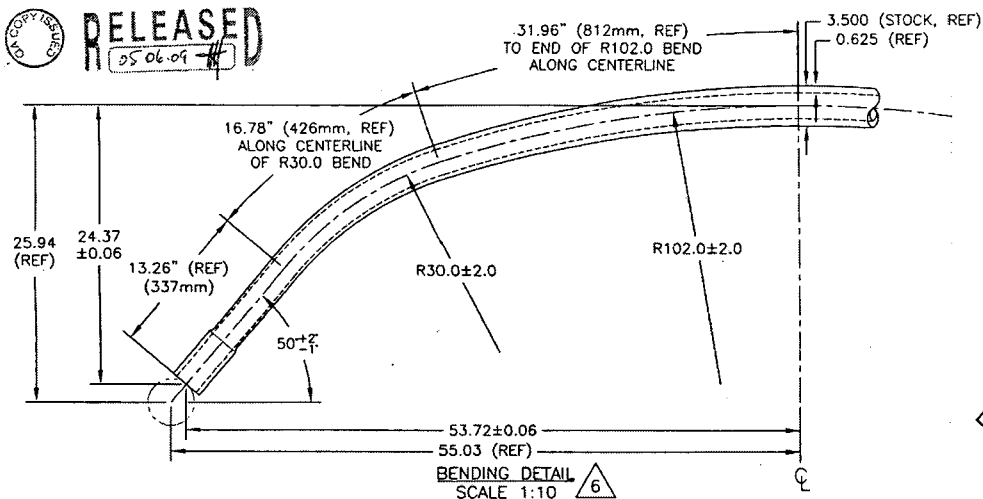
SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26673

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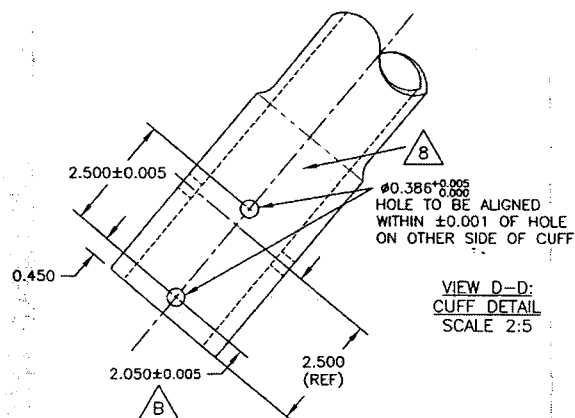
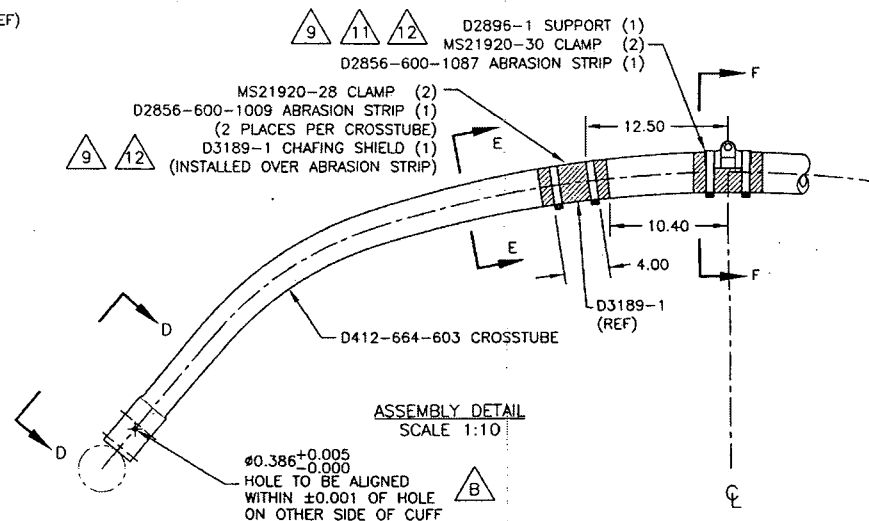


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05 06 09

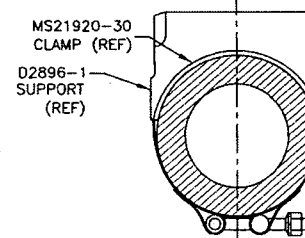


MS21920-28 CLAMP (REF)

NO. 20673
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SECTION F-F
SCALE 2:5

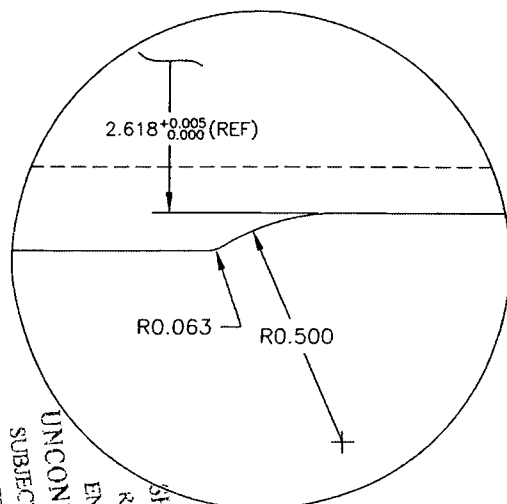
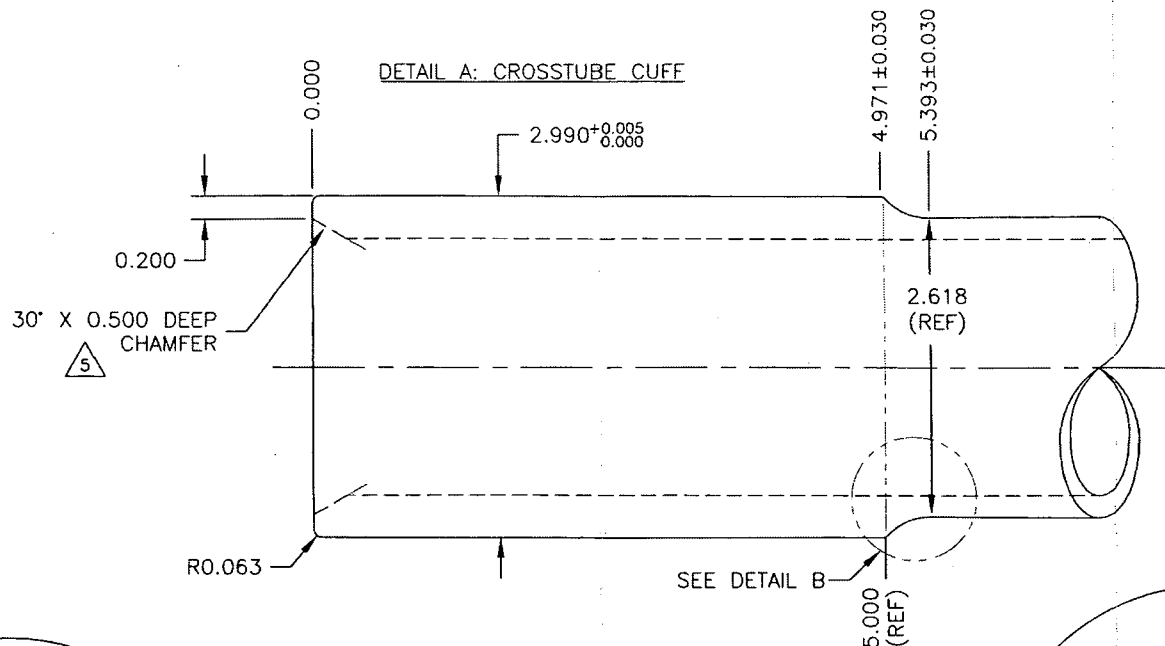


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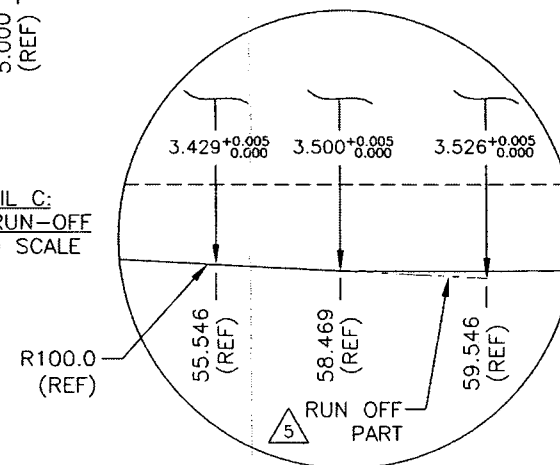
DESIGN	PH	DRAWN BY	PH	DART	DART AEROSPACE LTD. HAMPSHIRE, ENGLAND, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	REV. B
DATE	05.02.04			D412-664-243	SHEET 2 OF 3
				TITLE	SCALE
				CROSSTUBE ASSEMBLY (412 HI AFT)	1:10

RELEASED
65.06.09



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE

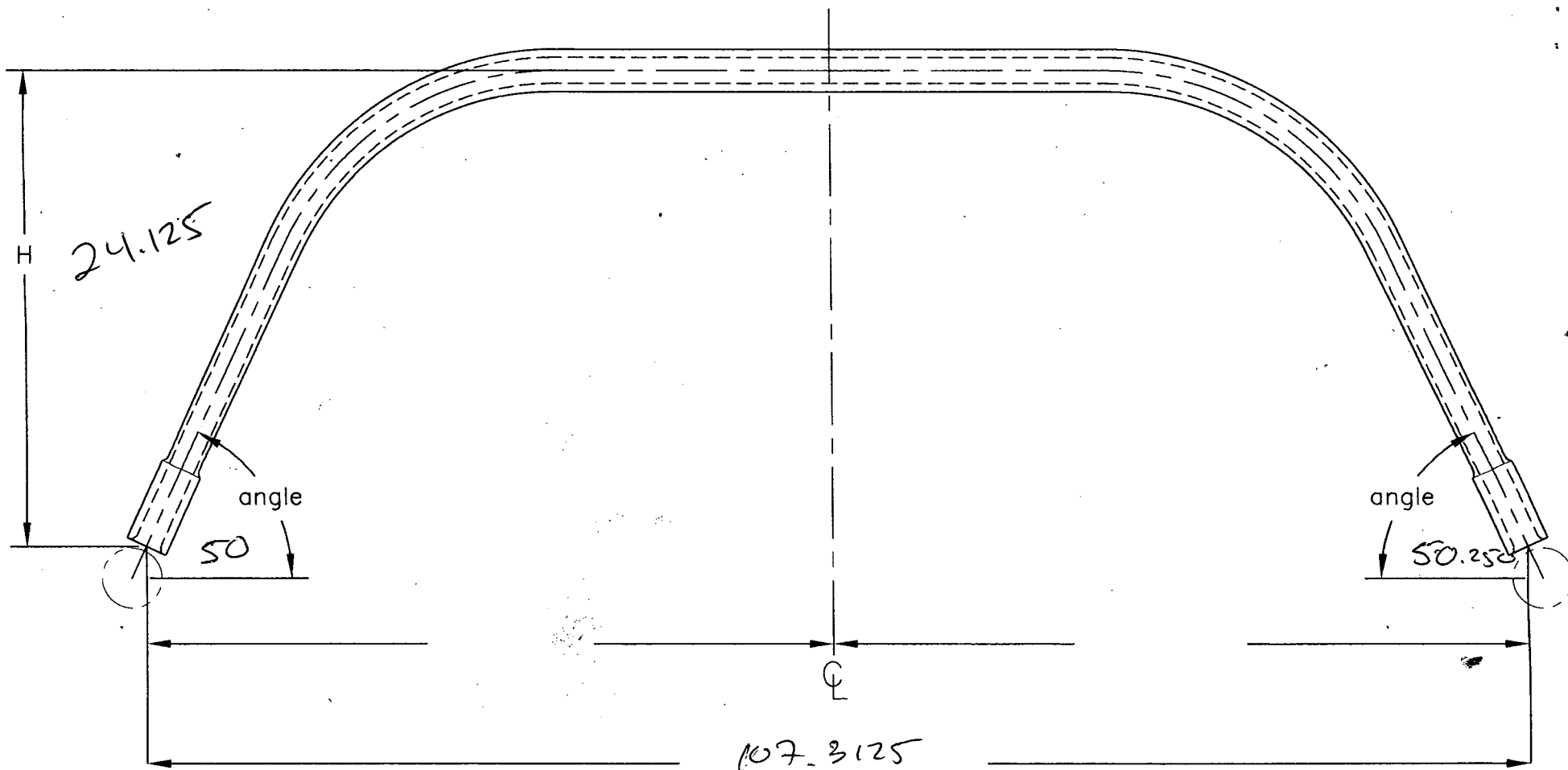


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DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD. MISSISSAUGA, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D412-664-243	REV. B SHEET 3 OF 3
DATE 05.02.04	TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	SCALE 1:1	

NO. 26673
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY



DATE: 06.05.31

DESCRIPTION: 412-664-203

BATCH NO: 26673

DRAWING: 412-664-243 R.B

H: 24.37 } ± 1.000

1/2 SPAN: 53.72

TOTAL SPAN: 107.44

ANGLE: 50 ± 2

[Signature]
06.05.31
[Signature]



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 34275

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of (12) cross tube (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (7) P/N D058-676-201 S/N's B19627, B19633, B19631, B19635, B19632, B19624 & B19630
Qty (5) P/N D412-664-203 S/N's B27082, B26672, B27084, B27083 & B26673



RADIOGRAPHY



ULTRASONIC



PENETRANT



MAGNETIC PARTICLE



EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (12) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

(12) cross tubes PASSED inspection.

~~THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS~~

INSPECTED BY: 

DATE June 8, 2006

INSPECTION
STAMP(S) Not Required

CUSTOMER INFORMATION

CUSTOMER Dart Aerospace

P.O. NUMBER

1386

ADDRESS:

CONTACT NAME:

LABOUR @

\$

MATERIALS @

TRAVEL EXPENSES @

GST

HOTEL EXPENSES @

PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT

Date: Wednesday, 04/10/2006 10:34:53 AM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D28961
Job Number : 28866	
Estimate Number : 10804	
P.O. Number : <i>N/A</i>	Part Number : <i>D28961 D412-664-203</i>
This Issue : 04/10/2006 S.O. No. : <i>N/A</i>	Drawing Number : REMOVE SUPPORT
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : LANDING GEAR	Drawing Revision : <i>N/A</i>
Previous Run : 00015	Material : <i>N/A</i>
Written By : _____	Due Date : 11/10/2006 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : _____	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
Comment: LANDING GEAR RESOURCE 1 REMOVE FROM STK 1 X D412-664-203 B <i>27179</i> REMOVE FROM CROSSTUBE 1 X D2896-1 SUPPORT B <i>26683</i> (REF W/O 27179)		
2.0	D412664203	Crosstube Aft High
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Crosstube Aft High		
3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
Comment: LANDING GEAR RESOURCE 1 WHEN STK- REASSEMBLE SUPPORT ON CROSSTUBE D2896-1 B _____		
4.0	D28961	Support
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Support		

3.0

06.10.31

Support will be
installed on w/o 29190

B 06.10.31

Date: Wednesday, 04/10/2006 10:34:53 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D28961

Job Number: 28866

Part Number: D28961

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REPACKAGE PER PPP

USING NEW B/N

NEW LABELS REQUIRED

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 06-10-31

Process Sheet

ner: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Number: 27179

Part Number: D412664203

Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

19.0

D2856600

Abrasion Strip



Comment: Qty.: 1.7640 f(s)/Unit Total : 1.7640 f(s)

Pick:

Qty Part number Description Batch

2 D2856-600(Cut to 10.090") Abrasion Strip B24328

RT 06-08-31

20.0

D2856600

Abrasion Strip



Comment: Qty.: 1.0080 f(s)/Unit Total : 1.0080 f(s)

Pick:

Qty Part number Description Batch

1 D2856-600(Cut to 10.870") Abrasion Strip B24328

RT 06-08-31

21.0

D28961

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2896-1 Support B26683

RT 06 08 31

22.0

D31891

Chafing Shield



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D3189-1 Chafing Shield B26687

RT 06 08 31

REFERENCE ONLY

23.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28 Clamp M100479

RT 06 08 31



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél: (514) 636-1000 • Fax: (514) 636-0031

W.O. No 34275

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of (12) cross tube (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.
Qty (7) P/N D058-676-201 S/N's B19627, B19633, B19631, B19635, B19632, B19624 & B19630
Qty (5) P/N D412-664-203 S/N's B27082, B26672, B27084, B27083 & B26673



RADIOGRAPHY



ULTRASONIC



PENETRANT



MAGNETIC PARTICLE



EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (12) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

(12) cross tubes PASSED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:


S. FLETCHER

DATE:

June 8, 2006

INSPECTION
STAMP(S)

Not Required

CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER:

1386

ADDRESS:

CONTACT NAME:

LABOUR

@

\$

MATERIALS

@

TRAVEL EXPENSES

@

GST

HOTEL EXPENSES

@

PST

INVOICE NO.

TOTAL \$

WHITE COPY-INSPECTION FILE • YELLOW COPY-CUSTOMER • PINK COPY-ACCOUNTANT